



Push must ship 22/06

Dart Aerospace Ltd.

Date: Thursday, 14/06/2007 10:30:20 AM  
User: Linda Lacelle

## Process Sheet

<b>Customer</b> : CU-DAR001 Dart Helicopters Services	<b>Drawing Name</b> : 206 L/L 1/L3 SCUFF PLATE, AFT LH
<b>Job Number</b> : 32909	
<b>Estimate Number</b> : 12336	
<b>P.O. Number</b> : N/A	<b>Part Number</b> : D206555007
<b>This Issue</b> : 14/06/2007	<b>Drawing Number</b> : D206-555 REV C
<b>Prsht Rev.</b> : NC	<b>Project Number</b> : N/A
<b>First Issue</b> : N/A	<b>Drawing Revision</b> : C
<b>Previous Run</b> : 32909	<b>Material</b> : N/A
<b>Written By</b> : 	<b>Due Date</b> : 22/06/2007
<b>Checked &amp; Approved By</b> : 	<b>Qty:</b> 10 <b>Um:</b> Each
<b>Comment</b> : Est: C 99.08.23 Returned to Electro Polish DM Est Rev:D Now on WaterJet 07-06-14 JLM	

### Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

1.0	DC	DOCUMENT CONTROL
-----	----	------------------



**Comment:** DOCUMENT CONTROL  
Type Labels as per PPP D206-555-007

2.0	M304S25GA	304/316 .020" Sheet
-----	-----------	---------------------



**Comment:** Qty.: 0.4410 sf(s)/Unit Total : 4.4100 sf(s)  
304/316 .020" Sheet  
Batch: M103 504

QC2	INSPECT PARTS AS THEY COME OFF MACHINE
-----	--



**Comment:** INSPECT PARTS AS THEY COME OFF MACHINE

QC8	SECOND CHECK
-----	--------------



**Comment:** SECOND CHECK

5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
-----	-------------	-------------------------------



**Comment:** SMALL & MEDIUM FAB RESOURCE 1

Form parts on hydraulic press as per Dwg. D206-555 using DT8320-7  
Finish form on bench forming Jig DT8321-7  
Remove tooling tabs and deburr

FF 07-10-23  
FF 07-10-18

Date: Thursday, 14/06/2007 10:30:20 AM  
User: Linda Lacelle

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206 L/L 1/L3 SCUFF PLATE, AFT LH

Job Number: 32909

Part Number: D206555007

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



*Handwritten: 7/10/05 (13)*



Comment: INSPECT WORK TO CURRENT STEP

7.0

OUTSIDE SERV.20

OUTSIDE SERVICE - SF



Comment: Sub-Contracting Outside services

Electrochemically polish per ASTM B912, High shine finish, No scratches on surfaces.

Issue P/O: *4886 C207/10/05* (8)

Possible supplier: TQF Technologies

*Handwritten: 7/10/05 (8)*

8.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Receive and Inspect for transit damage

9.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

*Handwritten: 7/11/05 (8) counter*

10.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: \_\_\_\_\_

*Handwritten: (X8) 07/11/05 AS*

11.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

*Handwritten: 07/11/05*

Job Completion



*Handwritten: C207/11/05*

Date: Thursday, 14/06/2007 10:08:05 AM  
 User: Linda Lacelle

## Process Sheet

Customer : CU-DAR001 Dart Helicopters Services  
 Job Number : 32909  
 Estimate Number : 12336  
 P.O. Number :  
 This Issue : 14/06/2007 S.O. No. :  
 Prsht Rev. : NC  
 First Issue : / / Type : PURCHASED PARTS  
 Previous Run : 26228  
 Written By :  
 Checked & Approved By :  
 Comment : Est: C 99.03.23 Returned to Electro Polish DM

Drawing Name : 206 L/L 1/L3 SCUFF PLATE, AFT LH  
 Part Number : D206555007  
 Drawing Number : D206-555 REV C  
 Project Number : N/A  
 Drawing Revision : C  
 Material :  
 Due Date : 22/06/2007 Qty: 10 Um: Each

## Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 DC DOCUMENT CONTROL



Comment: DOCUMENT CONTROL  
 Type Labels as per PPP D206-555-007

2.0 PG PURCHASING



Comment: PURCHASING  
 Issue P/O: \_\_\_\_\_  
 Email or ship DXF file to vendor  
 Laser cut part as per DXF file  
 Material release note required

3.0 D206555007F Scuff Plate Aft LH 206L



Comment: Qty.: 1.0000 Each(s)/Unit Total : 10.0000 Each(s)  
 SCUFF PLATE FLAT

4.0 PACKAGING 1 PACKAGING RESOURCE #1





Comment: PACKAGING RESOURCE #1  
 Receive & Inspect For Transit Damage  
 Ensure material certification is attached

5.0 QC6 DIMENSIONAL CHECK



Comment: DIMENSIONAL CHECK

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	
07-06-18	7.0	Hand Polish using a buffer - Walter's blue & white metal Polish. Blue <sup>#</sup> WAL 07T905 M _____ AIR White WAL 07T906 M _____ AIR Dwg to be updated.				 07-06-19	 07-06-18	
07/09/19 07/10/19	7 7	Split w 1.0 split w 1.0	SB 07/09/19 SB 07/10/19		9			

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date &amp; initial all entries

Date: Thursday, 14/06/2007 10:08:05 AM  
User: Linda Lacelle

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206 L/L 1/L3 SCUFF PLATE, AFT LH

Job Number: 32909

Part Number: D206555007

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Form parts on hydraulic press as per Dwg. D206-555 using DT8320-7  
Finish form on bench forming Jig DT8321-7  
Remove tooling tabs and deburr

7.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

8.0

OUTSIDE SERV.20

OUTSIDE SERVICE - SF



Comment: Sub-Contracting Outside services  
Electrochemically polish per ASTM B912, High shine finish, No scratches on surfaces.  
Issue P/O: \_\_\_\_\_  
Possible supplier: TQF Technologies

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1  
Receive and Inspect for transit damage

10.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

11.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1  
Identify and Stock  
Location: \_\_\_\_\_

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

Date: Thursday, 14/06/2007 10:08:05 AM  
User: Linda Lacelle

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206 L/L 1/L3 SCUFF PLATE, AFT LH

Job Number: 32909

Part Number: D206555007

Job Number:



Seq. #:

Machine Or Operation:

Description :

12.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion





DESIGN JB	DRAWN BY <i>[Signature]</i>	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>PH</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D206-555	REV. C SHEET 1 OF 7
DATE 06.09.01		TITLE DOOR SILL SCUFF PLATES	SCALE NTS
A	89.06.08	NEW ISSUE	
B	98.10.26	RE-DRAWN ADDED D206-555-011/-012/-045	
C	06.09.01	REVISED FINISH PER NCR 016	

QTY REQUIRED			PART NO.	DESCRIPTION
-041	-043	-045		
X			D206-555-041	SCUFF PLATE KIT 206 A/B
	X		D206-555-043	SCUFF PLATE KIT 206 L/L1/L3
		X	D206-555-045	SCUFF PLATE KIT 206 L/L1/L3, EXECUTIVE INTERIOR
1			D206-555-001	FORWARD LH
1			D206-555-002	FORWARD RH
1			D206-555-003	AFT LH
1			D206-555-004	AFT RH
	1		D206-555-005	FORWARD LH
	1		D206-555-006	FORWARD RH
	1	1	D206-555-007	AFT LH
	1	1	D206-555-009	AFT RH
		1	D206-555-011	FORWARD LH
		1	D206-555-012	FORWARD RH

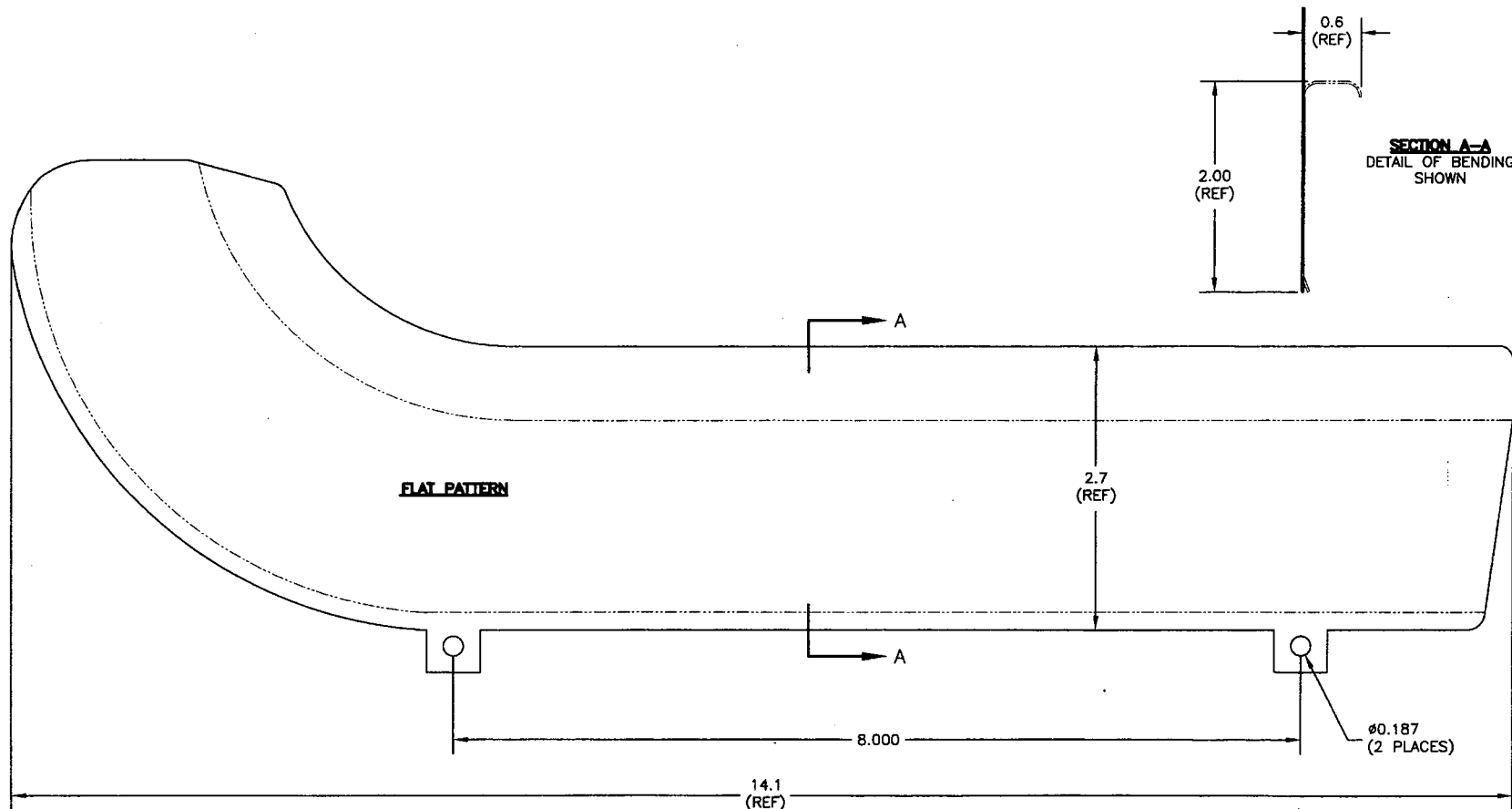
*W/O 32908*

RELEASED  
06.09.19 *[Signature]*

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**SECTION A-A**  
DETAIL OF BENDING  
SHOWN

**FLAT PATTERN**

**RELEASED**

06.04.19

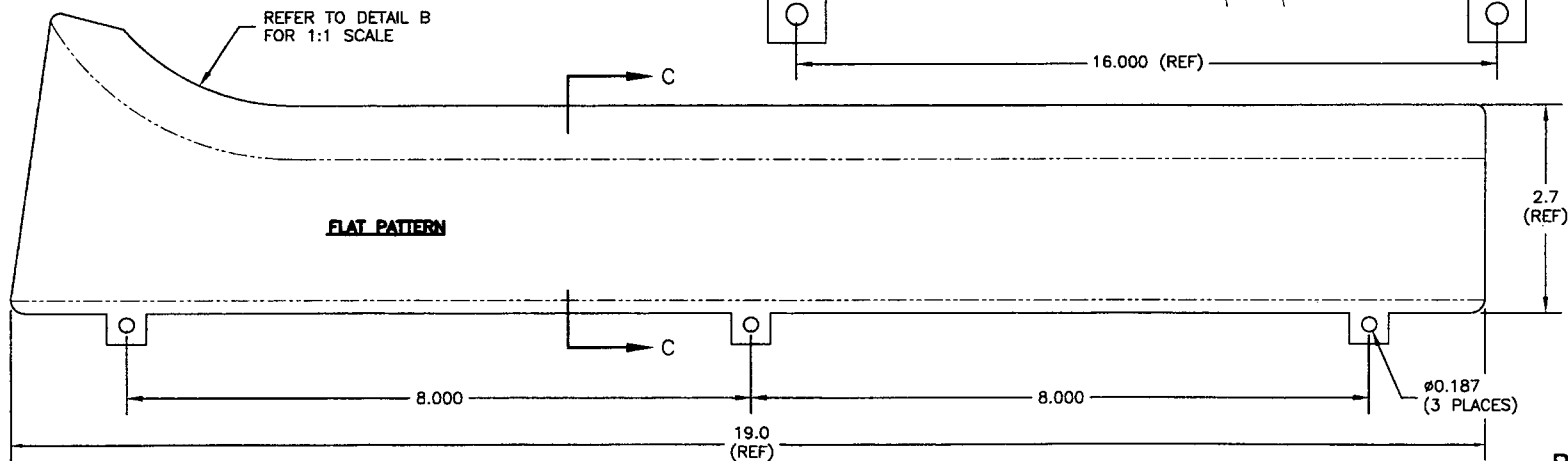
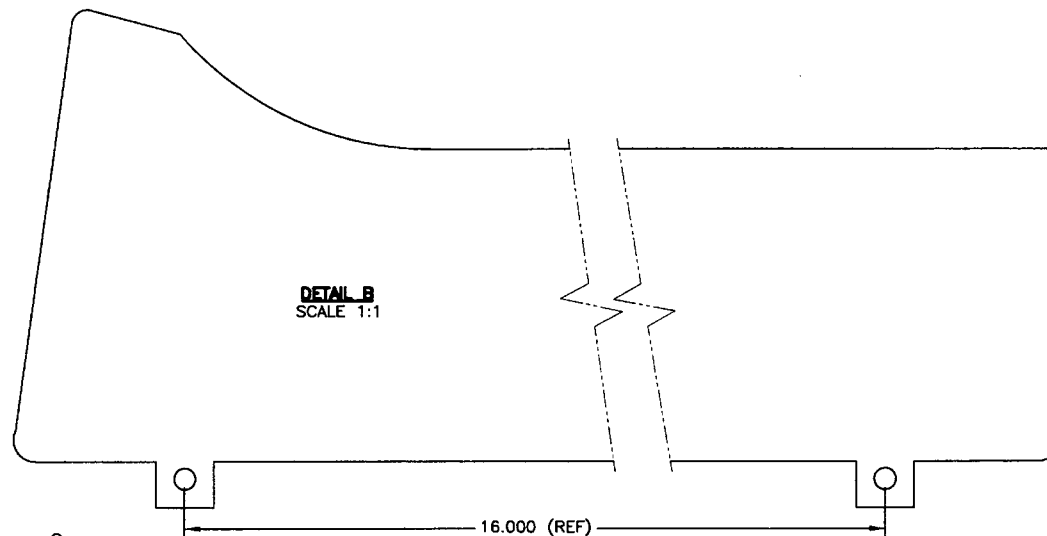
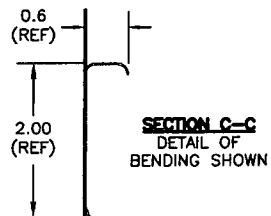
**D206-555-001 (BEND IN DIRECTION SHOWN IN SECTION A-A)**

**D206-555-002 (BEND OPPOSITE)**

**NOTES**

- 1) BEND PER M/F TEMPLATE D206-555-T1
- 2) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET, 0.020 THICK, PER MIL-S-5019 (ANNEALED) 2B FINISH  
(REF. DART SPEC. M304S25GA)
- 3) FINISH: ELECTROCHEMICALLY POLISH PER ASTM B912 (OR EQUIVALENT), HIGH SHINE FINISH, NO SCRATCHES ON SURFACES
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 5) TOLERANCES PER DART QSI 018 UNLESS OTHERWISE NOTED

DESIGN JB	DRAWN BY JB	<b>DART</b> DART AEROSPACE LTD MARKHAM, ONTARIO, CANADA
CHECKED PH	APPROVED PH	DRAWING NO. D206-555
DATE 06.09.01	TITLE DOOR SILL SCUFF PLATES	REV. C SHEET 2 OF 7 SCALE 1:1



**D206-555-003 (BEND IN DIRECTION SHOWN IN SECTION C-C)**  
**D206-555-004 (BEND OPPOSITE)**

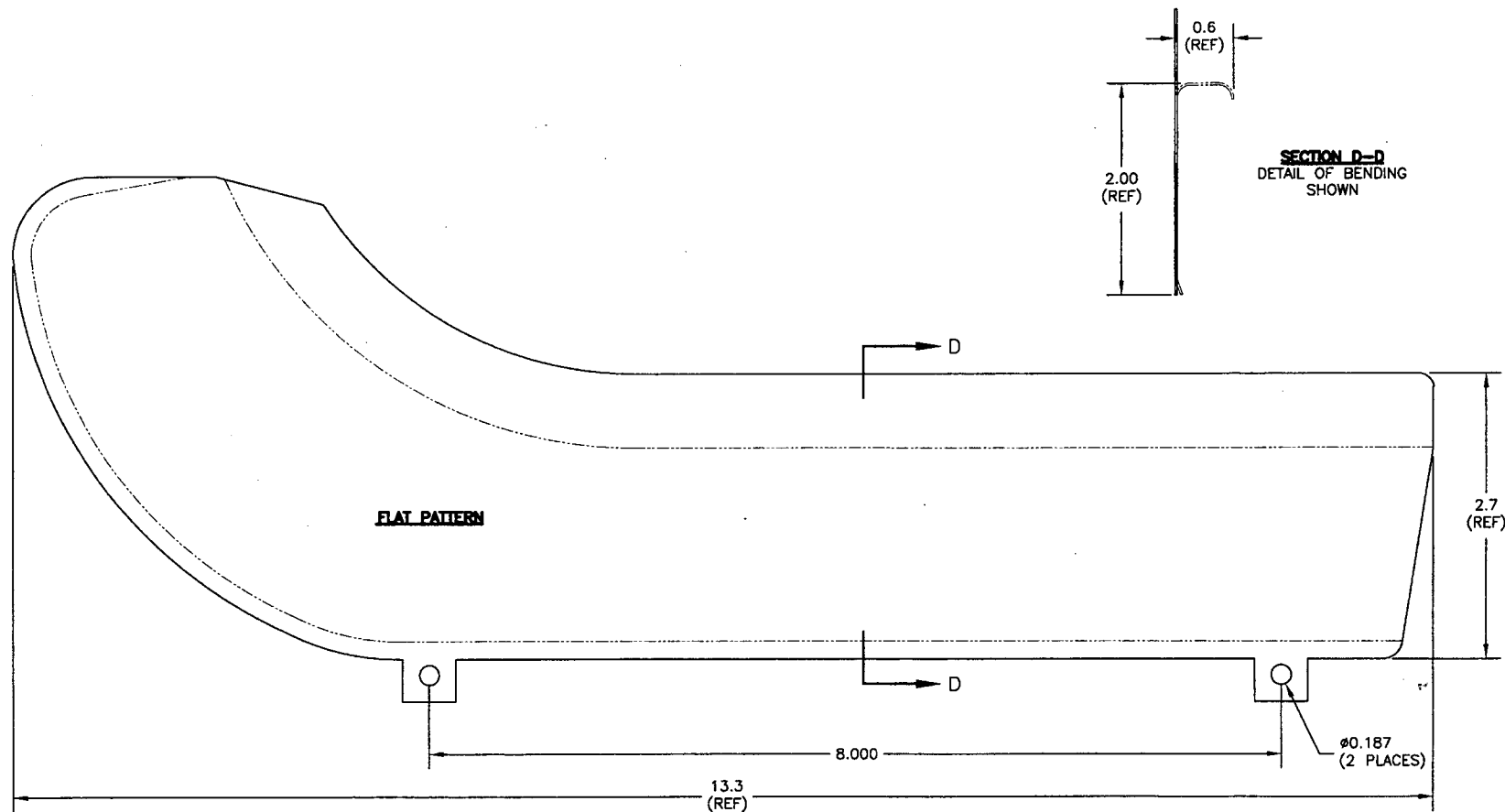
**NOTES**

- 1) BEND PER M/F TEMPLATE D206-555-T3
- 2) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET, 0.020 THICK, PER MIL-S-5019 (ANNEALED) 2B FINISH  
(REF. DART SPEC. M304S25GA)
- 3) FINISH: ELECTROCHEMICALLY POLISH PER ASTM B912 (OR EQUIVALENT), HIGH SHINE FINISH, NO SCRATCHES ON SURFACES
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 5) TOLERANCES PER DART QSI 018 UNLESS OTHERWISE NOTED

**RELEASED**

06-09-19-#

DESIGN JB	DRAWN BY JB	<b>DART</b> DART AEROSPACE LTD WARRICKSLEY, ONTARIO, CANADA
CHECKED RH	APPROVED BY RH	DRAWING NO. D206-555
DATE 06.09.01	TITLE DOOR SILL SCUFF PLATES	REV. C SHEET 3 OF 7 SCALE 2:3



**D206-555-005 (BEND IN DIRECTION SHOWN IN SECTION D-D)**  
**D206-555-006 (BEND OPPOSITE)**

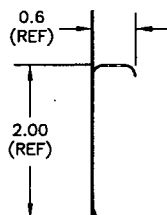
**NOTES**

- 1) BEND PER M/F TEMPLATE D206-555-T5
- 2) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET, 0.020 THICK, PER MIL-S-5019 (ANNEALED) 2B FINISH (REF. DART SPEC. M304S25GA)
- 3) FINISH: ELECTROCHEMICALLY POLISH PER ASTM B912 (OR EQUIVALENT), HIGH SHINE FINISH, NO SCRATCHES ON SURFACES
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 5) TOLERANCES PER DART QSI 018 UNLESS OTHERWISE NOTED

RELEASED

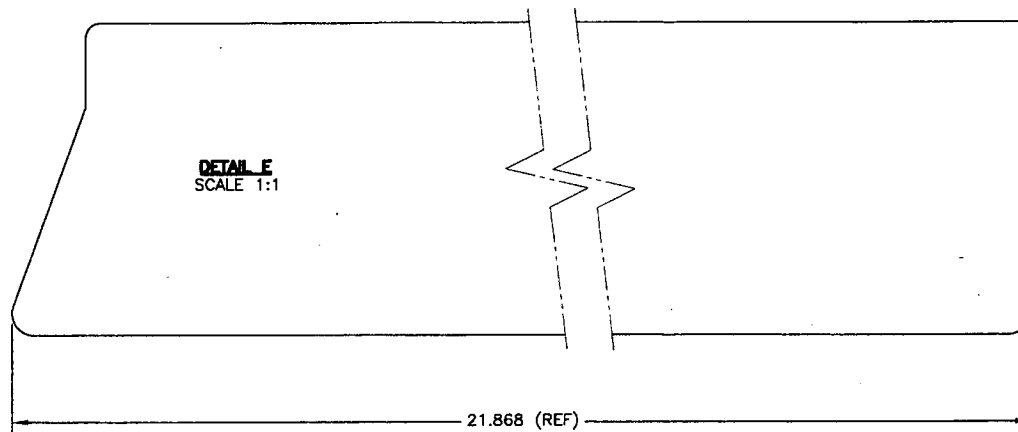
06-09-19

DESIGN JB	DRAWN BY [Signature]	<b>DART</b> DART AEROSPACE LTD HARRISBURG, ONTARIO, CANADA	
CHECKED [Signature]	APPROVED [Signature]	DRAWING NO. D206-555	REV. C SHEET 4 OF 7
DATE 06.09.01	TITLE DOOR SILL SCUFF PLATES		SCALE 1:1

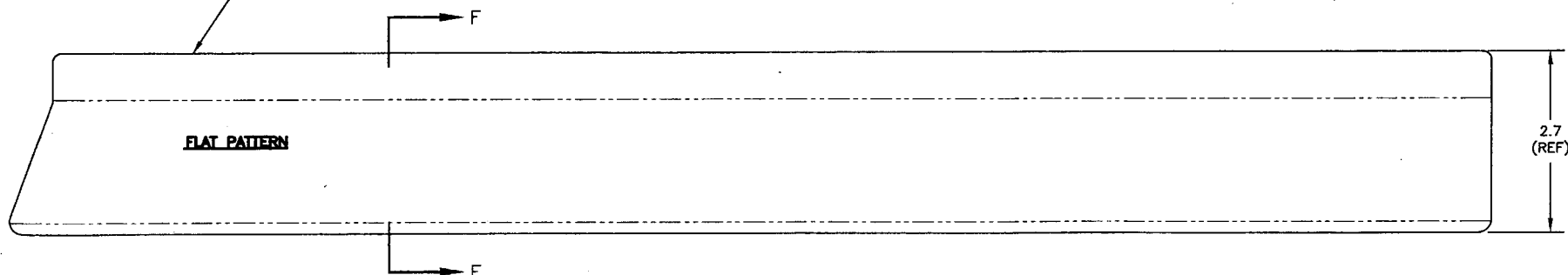


**SECTION F-F**  
DETAIL OF  
BENDING SHOWN

**DETAIL E**  
SCALE 1:1



REFER TO DETAIL E  
FOR 1:1 SCALE



**FLAT PATTERN**

RELEASED

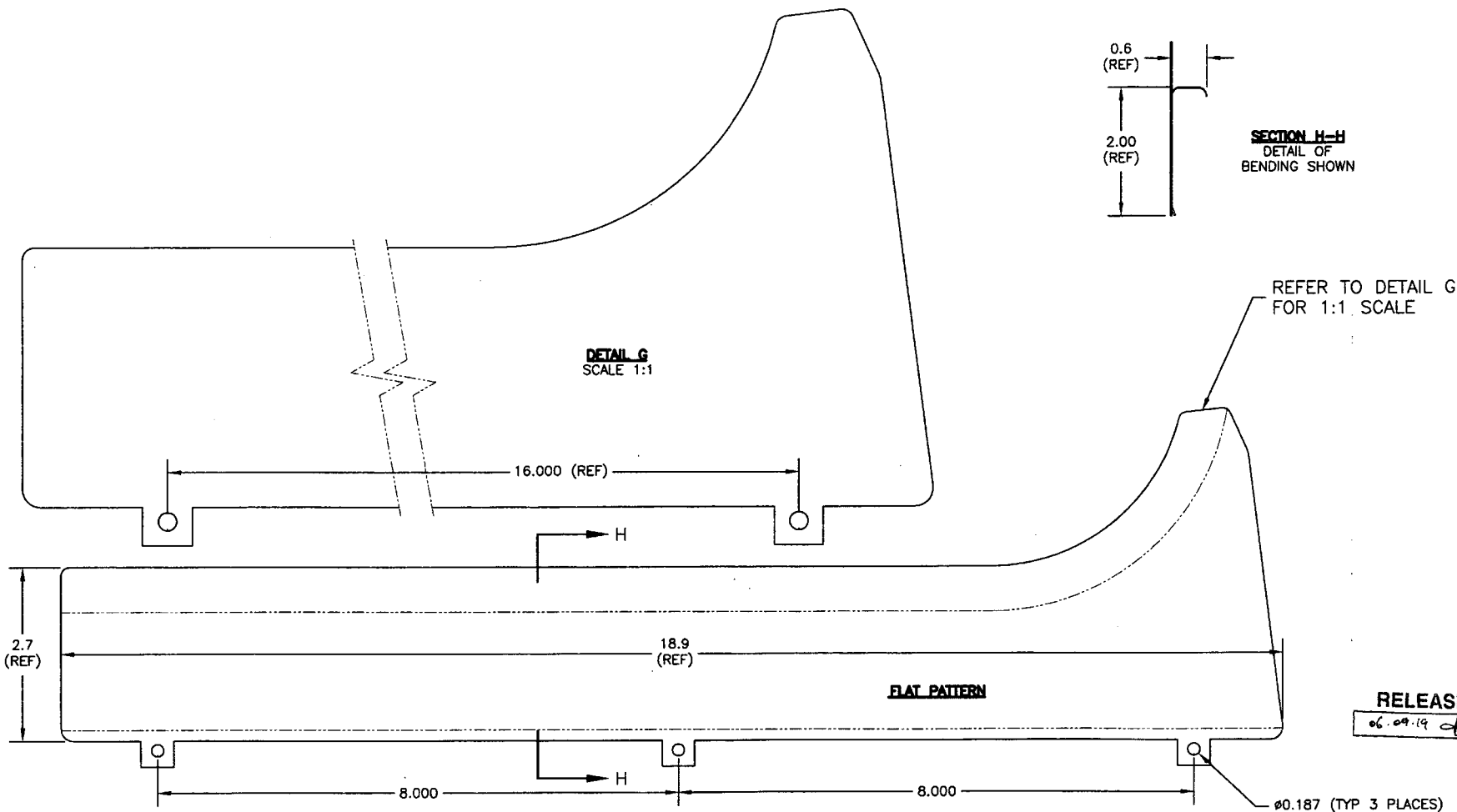
06.09.19 #

**D206-555-007 (BEND IN DIRECTION SHOWN IN SECTION F-F)**

**NOTES**

- 1) BEND PER M/F TEMPLATE D206-555-T7
- 2) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET, 0.020 THICK, PER MIL-S-5019 (ANNEALED) 2B FINISH (REF. DART SPEC. M304S25GA)
- 3) ~~FINISH: ELECTROCHEMICALLY POLISH PER ASTM B912 (OR EQUIVALENT), HIGH SHINE FINISH, NO SCRATCHES ON SURFACES~~ SEE W/O CHANGES STEP 7.0
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 5) TOLERANCES PER DART QSI 018 UNLESS OTHERWISE NOTED

DESIGN JB	DRAWN BY B	<b>DART</b> DART AEROSPACE LTD WINDSOR, ONTARIO, CANADA
CHECKED PH	APPROVED H	DRAWING NO. D206-555
06.09.01	06.09.19	TITLE DOOR SILL SCUFF PLATES
		REV. C SHEET 5 OF 7 SCALE 2:3



RELEASED

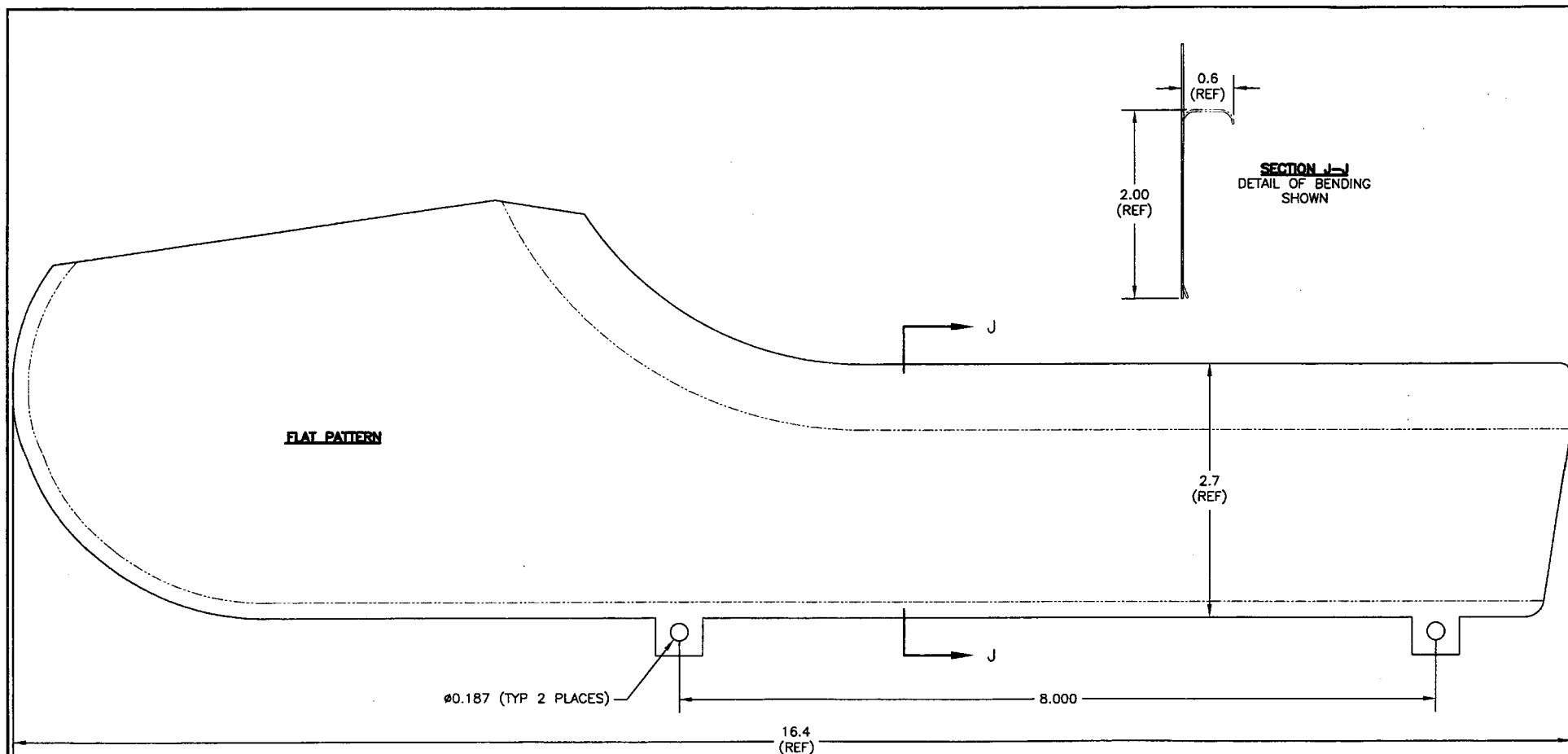
06.09.01

D206-555-009 (BEND IN DIRECTION SHOWN IN SECTION H-H)

# NOTES

- 1) BEND PER M/F TEMPLATE D206-555-T9
- 2) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET, 0.020 THICK, PER MIL-S-5019 (ANNEALED) 2B FINISH (REF. DART SPEC. M304S25GA)
- 3) FINISH: ELECTROCHEMICALLY POLISH PER ASTM B912 (OR EQUIVALENT), HIGH SHINE FINISH, NO SCRATCHES ON SURFACES
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 5) TOLERANCES PER DART QSI 018 UNLESS OTHERWISE NOTED

DESIGN JB	DRAWN BY JB	<b>DART</b> DART AEROSPACE LTD WINDSOR, ONTARIO, CANADA	REV. C
CHECKED PH	APPROVED PH	DRAWING NO. D206-555	SHEET 6 OF 7
DATE 06.09.01	TITLE DOOR SILL SCUFF PLATES	SCALE 2:3	



D206-555-011 (BEND IN DIRECTION SHOWN IN SECTION J-J)  
D206-555-012 (BEND OPPOSITE)

#### NOTES

- 1) BEND PER M/F TEMPLATE D206-555-T11
- 2) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET, 0.020 THICK, PER MIL-S-5019 (ANNEALED) 2B FINISH (REF. DART SPEC. M304S25GA)
- 3) FINISH: ELECTROCHEMICALLY POLISH PER ASTM B912 (OR EQUIVALENT), HIGH SHINE FINISH, NO SCRATCHES ON SURFACES
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 5) TOLERANCES PER DART QSI 018 UNLESS OTHERWISE NOTED

RELEASED

06-09-01

DESIGN JB	DRAWN BY JB	<b>DART</b> DART AEROSPACE LTD MISSISSAUGA, ONTARIO, CANADA
CHECKED PH	APPROVED PH	DRAWING NO. D206-555
DATE 06.09.01	TITLE DOOR SILL SCUFF PLATES	REV. C SHEET 7 OF 7 SCALE 1:1



DART AEROSPACE LTD		Work Order: 32909
Description: Scuff Plate		Part Number: D206 556 007
Inspection Dwg: D206-555 Rev: C		Page 1 of 1

### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Inspection Sheet Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
A 2.7	+/- 0.00	2.708	✓		Vern	
B 21.868	+/- 0.010	21.875	✓		M-T	
C 0.020	+/- 0.010	0.028	✓		Vern	
D						
E						
F						
G						
H						
I						
J						
K						
L						
M						
N						
O						
P						
Q						
R						
S						
T						
U						
V						
W						
X						
Y						

Measured by: SAA	Audited by: [Signature]	Prototype Approval: N/A
Date: 07/06/14	Date: 07/06/14	Date: N/A

Rev	Date	Change	Revised by	Approved
		New Issue	KJ/RF	





## Certificat de Conformité / Certificate of Compliance

A/TO: Dart Aerospace Ltd.

Date: November 1, 2007

1270 Aberdeen St

Hawkesbury, Ontario

No. de certificat  
Certification No.

K6A 1K7

tel.: (613) 632-5200

fax: (613) 632-1053

**C121120**

bon de T. Job No.	Qt	# de pièce / Part #	Remarques / Remarks
132319		<b>NO. DE COM./P.O.#</b> 4886	
	8	D206-555-002 CUST. REF.:B32855	ELECTROPOLISH PER ASTM B912 REV.02
	8	D206-555-007 CUST. REF.:B32909 ✓	
	9	D206-555-009 CUST. REF.:B32767	

*Nous certifions que les parties listées ci-dessus ont été faites et inspectées en conformité avec votre bon de commande, vos dessins et spécifications et sont en accord avec les exigences ci-inclus.*

*We hereby certify that the parts listed above have been processed and inspected in accordance with your purchase order, drawings and specifications, and are correct with regard to the requirements contained therein.*

Signé pour et au nom de TQF Technologies Inc.  
Signed for and on behalf of TQF Technologies Inc.




Raj Thakoordeen

Total Quality Finishing